

Thursday, 7/19/2007 2:26:48 PM
Kim Johnston

Process Sheet

SPLit

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT FOR D206-642-511
 Job Number : 33664 -2
 Estimate Number : 12893
 P.O. Number : N/A
 This Issue : 7/19/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 33484
 Written By :
 Checked & Approved By : 07.07.19
 Comment : Est Rev:A 07.06.05 new issue EC

Part Number : K642 511
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : N/A
 Material : N/A
 Due Date : 8/3/2007

Qty: 3/ Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-511 CHG003

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D206648013 GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

GHW Kit

Batch: B33666(2x) - 33231 50 7/18/08

4.0 D2652 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

B32621 (28x) - B32987 (36x) -

5.0 D2712 Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

B32506 -

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 33664

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

B32021 (3x)

B33654 (x)

7.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

B33353 (3x) B32379 (x)

8.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B32628

9.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B33219

10.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-1

Saddle

B33355

11.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

34145

EP 07/08/08 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

B32784 -

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

B33375 (H) - B32893 (34) -

14.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

B33276 -

15.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

B32409 -

16.0

AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

M104955 -

17.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

M101261 -

7/19/08/68 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M105118 (25x) - M105160 (7x) -

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M104936 -

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M105143 -

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M104936 -

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M104936 -

23.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M101291 -

CP 08/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

AN5C32A



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M105156-

25.0

AN5C34A



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M18918-

26.0

AN5C35A



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M18918-

27.0

AN960C10L

washer



EP



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M104537-

28.0

AN960C416L

WASHER



EP



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M104916 (19)

M104936

(772)

EP 07/18/08 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

M105344

30.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

M104995

31.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

M104936

32.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

M104729

33.0

NAS1515H3L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H3L

Washer

M104291

34.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24

EP 07/08/08 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/08/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33664

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24 NAS1515H4L Washer M105136 -

35.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H5

Washer

M105135 -

36.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H5L

Washer

M104956 -

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

0708.24 (3) kits

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location: Phg

0708.24 3

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

0708.24 (3)

Job Completion



0708.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries